

Date: Tuesday, 12/5/2006 8:14:18 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE BLOCK		
Job Number	: 29770		Part Number	: D1049		
Estimate Number	: 10324		Drawing Number	: D1049 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/5/2006 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/15/2007 Qty: 50 Um: Each		
Previous Run	: 27073					
Written By	: <i>JL</i>					
Checked & Approved By	: <i>JL 06/12/09</i>					
Comment	: Est RevC 02.04.10 Re-format NG					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250 
2.0	SHEAR	SHEAR 
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
5.0	QC8	SECOND CHECK 

**Comment:** Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)  
 Material: 6061-T6 bar .750 wide x .250 thick.  
 Batch *M19380*

**Comment:** SHEAR  
 Cut Blanks: 2.000" long *JL 06/12/09*

**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per folio FA217 & Dwg D1049  
 2-Deburr *JL 06/12/10*

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE *J.L 06/12/10*

**Comment:** SECOND CHECK *JL 06/12/10*

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:18 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 29770

Part Number: D1049

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



49

00

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.R./J*

06/12/21

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*JL/AM* 07/01/03

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PC* 7/1/3 49

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5709*

*PC* 7/1/3

49

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*101.01.05*

Job Completion



*27.06.05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1049 PAR #: N/A Fault Category: CNC NCR: Yes No DQA: AA Date: 07.01.05  
 QA: N/C Closed: AA Date: 07.01.05

NCR: 29110		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.12.21	6.0	I part found with a deep knick on the side approximately .040 deep. R.C. - mat'l handling: <u>scraps</u>	<u>1</u> 06.12.21 031042	<u>scraps destroy</u>	<u>M.D.</u>	<u>1</u> 06.12.21	<u>1</u> 06.12.21 031042	<u>1</u> 06.12.21

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<u>29770</u>
<b>Description:</b> Saddle	<b>Part Number:</b>	D1049
<b>Inspection Dwg:</b> D1049	<b>Rev:</b> --	<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

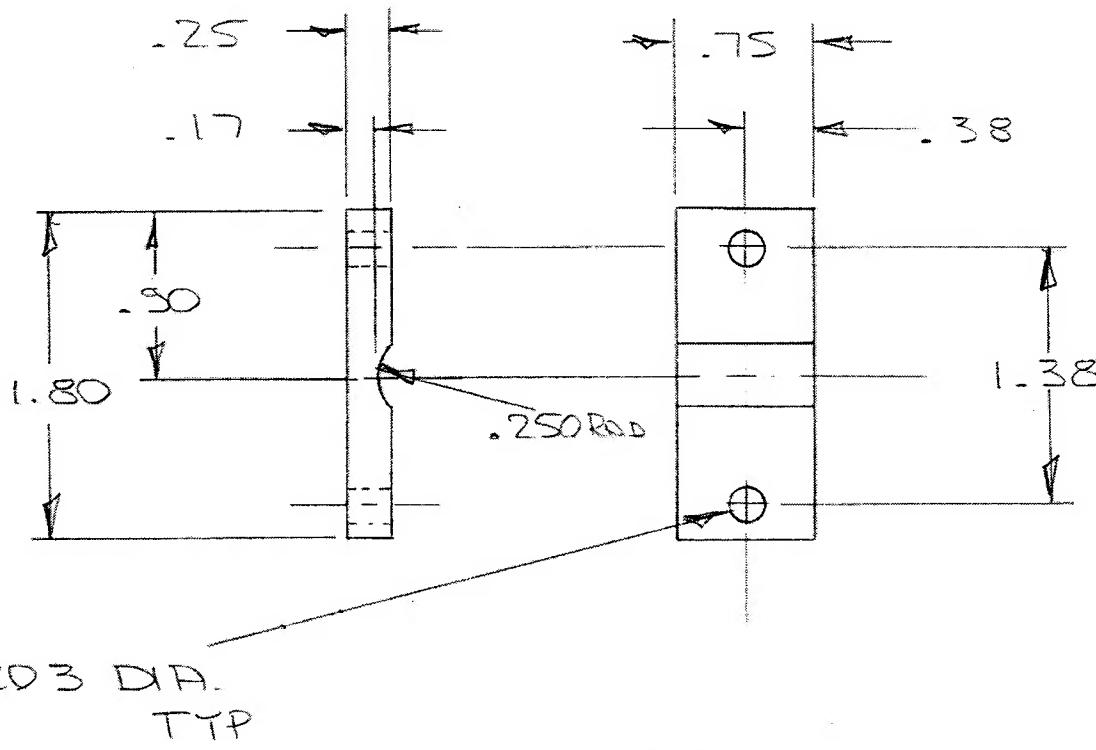
## X First Article      Prototype

Measured by:	J.L	Audited by:	ml	Prototype Approval:	N/A
Date:	06/12/09	Date:	06/12/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF <i>✓</i>	<i>✓</i>

RELEASED  
97/08/02 BW

97/0802 Bw



MATERIAL : SOSZ-H32

FINISH: POWDER COAT

SHOP COPY  
RETURN TO  
ENGINEERING COPY  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29170

